

**Work Order ID 74748**

October 6, 2011 7:46:59 AM

**\*74748\***

Page 1

Item ID: D2596

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Web, 205 Skidtube

Start Date: 10/06/11 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 10/11/11 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2596

Rev D

100

0.00


**\*100\***

Skidtubes

Skidtubes

Skidtubes

Memo

- 1- Cut D2500-3-100 to length: 99.5"  
2- Use Jig DT8093 to drill pilot holes #30  
3- Open to 0.630" diameter as per Dwg D2596  
4- Deburr
- 

0.00

110

0.00

**\*110\***

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

120

0.00

**\*120\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

4T 11-10-12

4T 11-10-12

DP 11-10-12 (10)

RTO

W/O: 74748

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

*Sapa Canada* *See Pink NCR 11-904*

Part No: D2596 PAR #: \_\_\_\_\_ Fault Category: Supplier NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR) 15.03						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-10-12	106	defect in mat'l D2500-3-100 R.C. Process (Bubbles in mat. see p. chng)	<i>CP</i> 11.10.11 05/04/12	scrap + destroy 1 D2500-3-100 I beam extrusion B66298 P.O. 13459	<i>RS</i> 11-10-12	<i>DD</i> 11-10-12	<i>CP</i> 11.10.11 05/04/12	<i>S</i> 11/10/17

NOTE: Date &amp; initial all entries

**Work Order ID 74748**

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**\*74748\***

Page 2

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Required Date: 10/11/11 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: **46**

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

**11-10-12****11/10/12****11-10-12**

# Picklist Print

October 6, 2011 7:32:51 AM

Page 1

Work Order ID: 74748

Parent Item: D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 10/06/11

Required Date: 10/11/11

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: D99.02.02Changed QA to QC. Added Step 6 and CostDM  
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100 Ext'n - 1" Beam Web 4"		Manufactured	No			100	Each	101.0000	1	10			

RT 11-10-12

Location

Loc Qty

Loc Code

LG

101

51957

4

66298

97

X 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

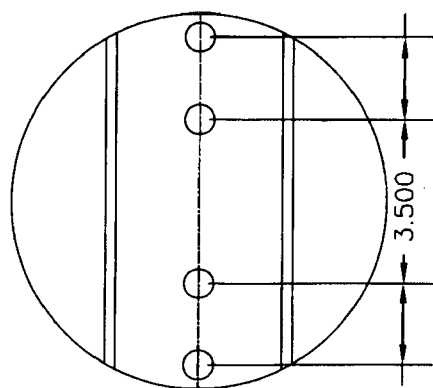
**NOTE:** Date & initial all entries



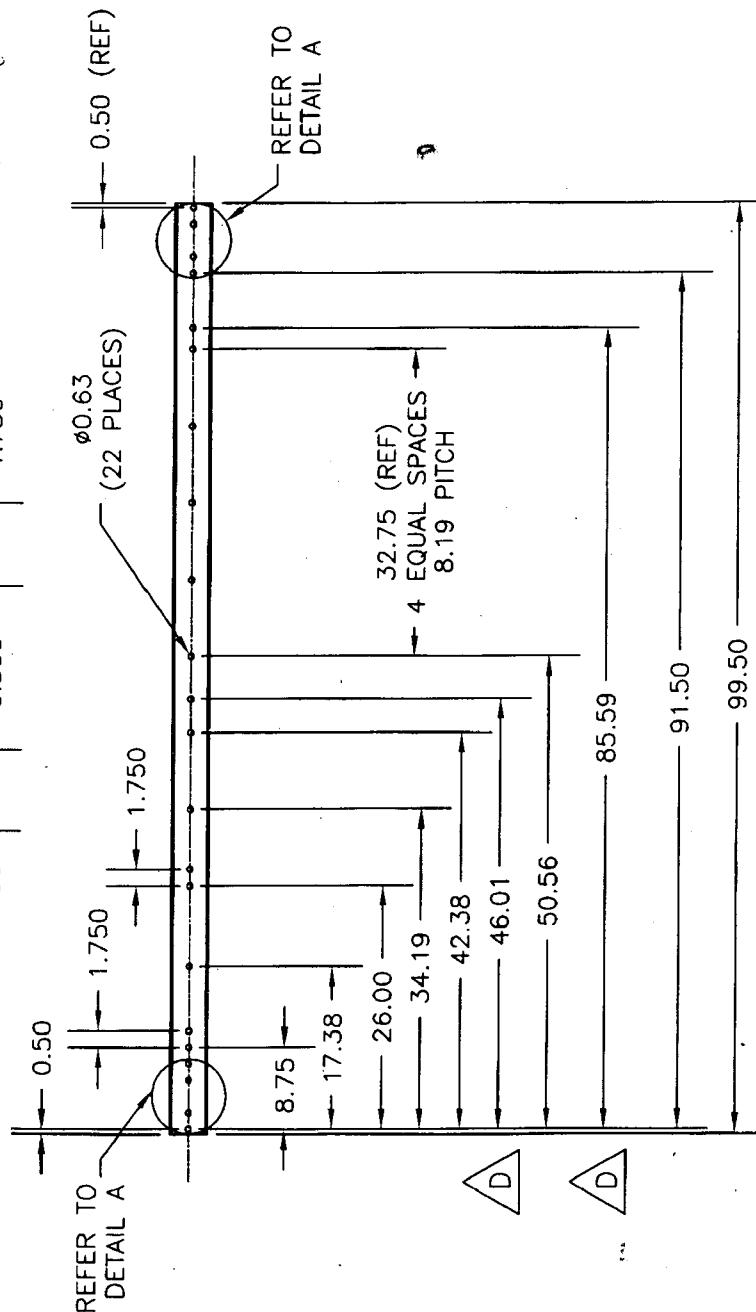
DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2596	REV. D SHEET 1 OF 1
DATE 07.04.17		TITLE 205 WEB	SCALE 1:20
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	

RELEASED  
07.06.18

*205*



DETAIL A  
SCALE 1:4



**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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